

January-17-12 11:51:09 AM

Item ID: D3791-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 17/01/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** M.L.J

Date: 12/01/17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | |
|-----------------|---------------------|--|
| Draw Nbr | Revision Nbr | |
| D3791 | Rev A | |

100

0.00

100

FLOW WATER JET

0.00

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg. D3791

Dwg Rev:

Prog Rev: _____

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

*** 1 1 0 ***

QC

Memo

Quality Control

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78897

78897

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 Revision ID: Stop ***NS2***
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 Start Date: 17/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | (412) | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | NC BRAKE | | | | | (12) | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | 1-Deburr if necessary | | | | | | | | |
| | 2-Form on Brake as per Dwg D3791 using Jigs | | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *140* | | | | | | (412) | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | Ensure joggle as per dwg D3429 | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | | 0.00 | | | | | | | |
| *150* | Large Fab | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1-Weld hardcoat as per dwg D3791 QSI004 | | | | | | | | |
| | Hardcoat 2059b Batch: <u>120645</u> | | | | | | | | |
| 160 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(x12) 31e/MAL 2012-02-23

lpl 12.02.24

12x Ø

m/ 12.02.25 (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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January-17-12 11:51:09 AM

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Start Date: 17/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 31/01/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Powder Coating

Memo

START TIME: 8:20

OVEN TEMPERATURE: 320 OF

FINISH TIME: 8:50

0.00

190

QC3- Inspect Part Finish

0.00

190

QC

Quality Control

Memo

0.00

200

Identify as per dwg & Stock Location F-P2

0.00

200

Packaging

Packaging

Memo

0.00

12x1/2 m / 12/02/27

12 x 1/2 m / 12/02/27

12x1/2 m / 12/02/27

m 118484

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

1165 12/02/28

Handwritten signature and date 12/20/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

January-17-12 11:51:12 AM

Page 1

Work Order ID: 78897

78897

Parent Item: D3791-1

D3791-1

Parent Item Name: Wearplate

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA | | Purchased | | No | | 100 | sf | 189.8300 | 0.2917 | 3.684632 | | | |

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

189.83

119346

29.5

119653

64.33

120243

96

4.0

90 12/02/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

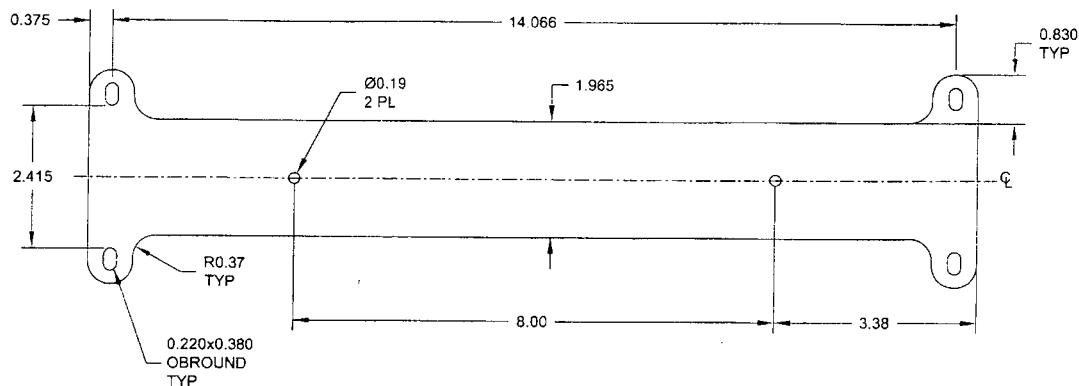
| W/O: | | WORK ORDER CHANGES | | | | | |
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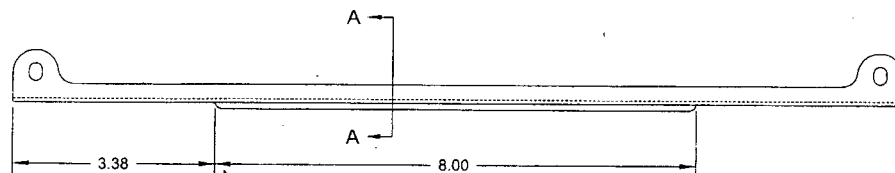
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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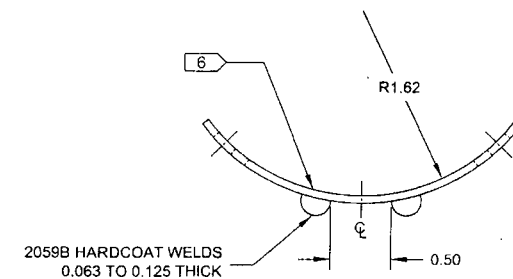
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
(MAKE FROM D3791-1F)



SECTION A-A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78893-4.25
12/01/17

RELEASED
05-21-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

| A | | NEW ISSUE | | PH | 08.05.13 |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------|----------|
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE USA, INC PORT HADLOCK, WA | | | |
| DRAWN | PH | | | | |
| CHECKED | | DRAWING NO. | | REV. A | |
| MFG. APPR. | | D3791 | | SHEET 1 OF 1 | |
| APPROVED | | TITLE | | SCALE | |
| DE APPR. | | WEARPLATE | | NTS | |
| DATE | 08.05.13 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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